

# Work Order ID 50869

July 23, 2009 9:44:08 AM



Page 1

Item ID: D3929-042

Accept



Setup Start



Revision ID: A

Item Name: Gusset Assembly

Stop



Start Date: 7/24/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 7/28/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3929

A

7

P70

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: *A*

Prog Rev: *A*

B 9-7-07

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-7-07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
050807	W/O Header	Add Dwg D3929 : Rev. A to the header. Perm change	BE	09.09.10		0506-07	0506-07	
<del>05-06-07</del>	<del>130</del>	<del>Route 130 parts New wing original Qty was changed 2006-07</del>						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

130

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

140

0.00

Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M109213

=> 805/4/27

(42)

f

6/10/09-07-30

6/10/09-07-30

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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July 23, 2009 9:44:08 AM

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Revision ID: A

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Start Date: 7/24/2009 Start Qty: 6.00

Required Date: 7/28/2009 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

PD 09.01.30 7

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

20 502/07/30

(7) 7

170

Identify as per dwg & Stock Location: Basket 0.00

Packaging

Memo

0.00

Packaging

PD 09.01.30 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Page 4

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Revision ID: A

Stop



Item Name: Gusset Assembly

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Cust Item ID:

Required Date: 7/28/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

50869-10  
A

U 09-08-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

July 23, 2009 9:44:07 AM

Work Order ID: 50869

Parent Item: D3929-042RevA

Parent Item Name: Gusset Assembly

Comments:



Start Date: 7/24/2009

Required Date: 7/28/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	108.5733	2.8421			



304/316 0.125 Sheet

4737 unit  
17 3,3159

Warehouse  
Location

Main Warehouse

MAT

111018

Loc Qty

108.5732632

108.573263

Loc Code

130

Each

8.0000

12.0000

D3907-1RevA



Bushing

Manufactured

No

Warehouse  
Location

Main Warehouse

ST

50517

Loc Qty

8

8

Loc Code

50944

111018

18 9-7-07



14

see p10

never  
mild

6/20/09.07.28 ?

6/20/09.07.30

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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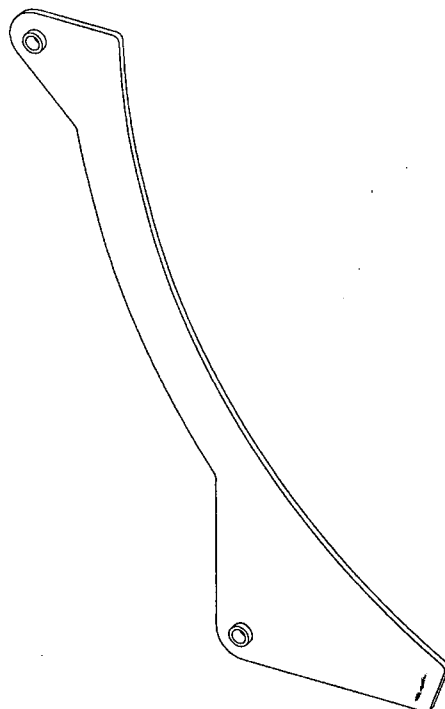
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

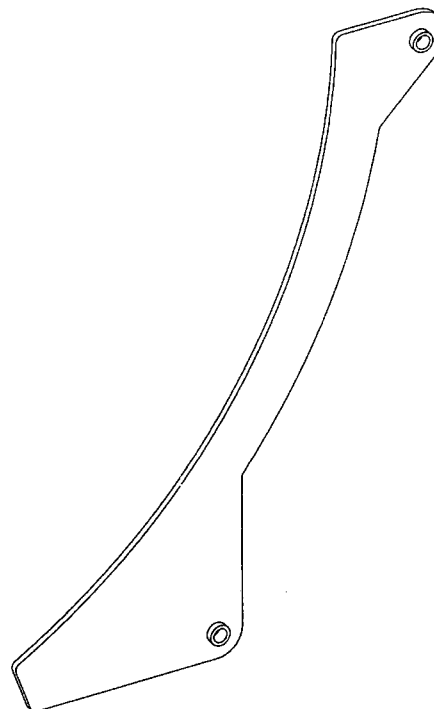
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



**D3929-041 GUSSET ASSEMBLY**



**D3929-042 GUSSET ASSEMBLY**

*u/o 50889*

**RELEASED**  
*8/24/12 MD*

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.73 lbs EACH
  - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	DESCRIPTION	MB	09.04.03
REV.			BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3929	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		GUSSET ASSEMBLY	NTS	
DATE	09.04.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

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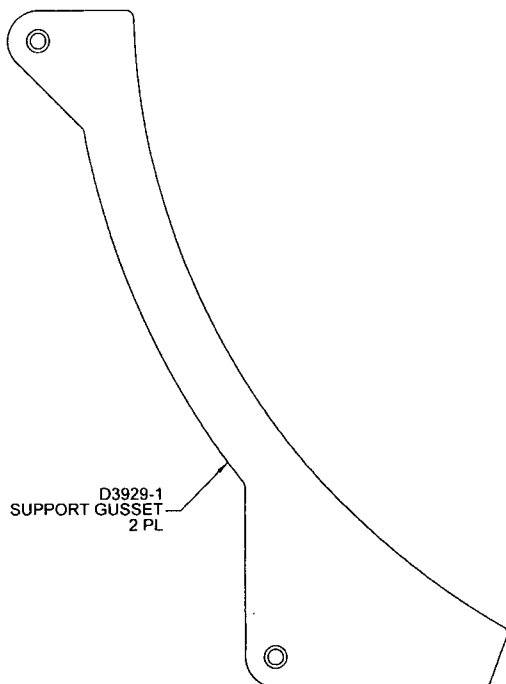
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

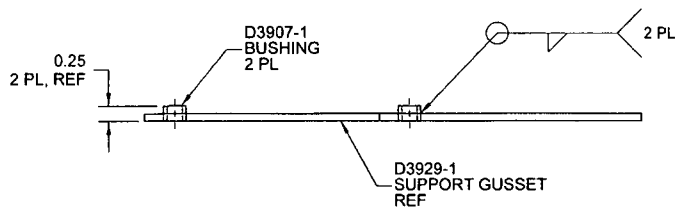
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W/O 50869



D3929-1  
SUPPORT GUSSET  
2 PL

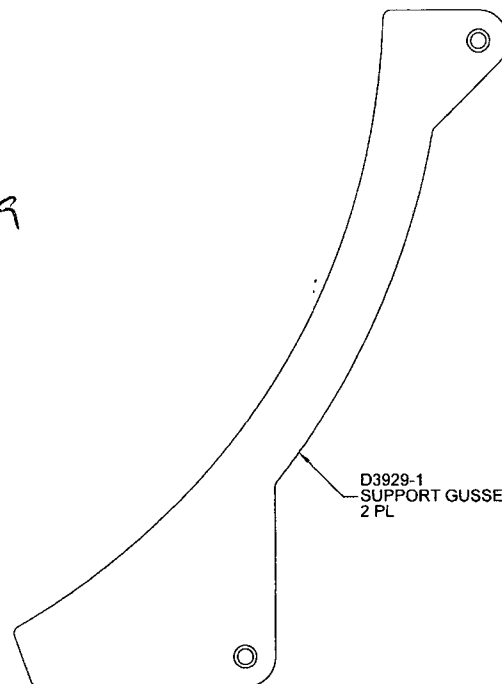


0.25  
2 PL, REF

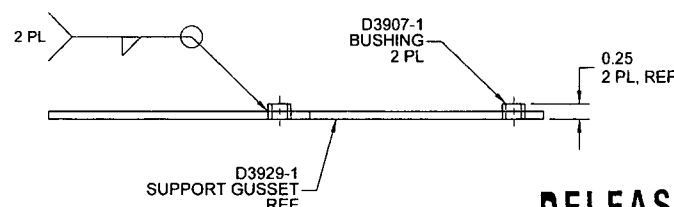
D3907-1  
BUSHING  
2 PL

D3929-1  
SUPPORT GUSSET  
REF

**D3929-041 GUSSET ASSEMBLY**



D3929-1  
SUPPORT GUSSET  
2 PL



0.25  
2 PL, REF

D3907-1  
BUSHING  
2 PL

D3929-1  
SUPPORT GUSSET  
REF

**D3929-042 GUSSET ASSEMBLY**

**RELEASED**  
09/04/22

W/O 50869

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3929</b>	REV. A
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>GUSSET ASSEMBLY</b>	NTS
DATE	<b>09.04.03</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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